

Work Order ID 83068

83068

Page 1

April 12 12:40:24 PM

Item ID: D3860-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate

Start Date: 12/04/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MC3

Date: 12/04/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3860	A
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100	FLOW WATER JET	0.00							
-----	----------------	------	--	--	--	--	--	--	--

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3860Dwg Rev: A Prog Rev: A 2-Deburr if necessary

304 .063

4 0 JM
12-5-22

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110

QC

Memo

0.00

Quality Control

4 0 JM
12-5-22

120	QC3- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

120

QC

Memo

0.00

Quality Control

74

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 83068

April-12-12 4:07:24 PM

83068

Page 3

Item ID: D3860-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30

M121279

3200F

4X 0 M.K 12/09/04

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

4 0 010-04

180

Identify as per dwg & Stock Location: 500

0.00

180

Packaging

Memo

0.00

Packaging

4 2 / SK 12/9/04

W/O:		WORK ORDER CHANGES					
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Work Order ID 83068***83068***

Page 4

April-12-12 4:07:24 PM

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

12/9/5 
H 12095

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April-12-12 4:07:29 PM

Page 1

Work Order ID: 83068

83068

Parent Item: D3860-041

D3860-041

Parent Item Name: Wearplate

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	239.8520	0.47	1.88			

M304S16GA

304/316 Sheet .063

**

Location	Loc Qty	Loc Code
MAT020	239.852	
120866	38.446	
120877	137.326	
121070	64.08	

D3009-3

Manufactured No

130 Each 32.0000 4 16

D3009-3

Cup

**

Location	Loc Qty	Loc Code
WA	32	
79078	30	
80095	2	

85503 X 16

120877

12-8-30

JM
12-5-22

W/O:		WORK ORDER CHANGES					
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3860-041	WEARPLATE
2	1	D3860-1	WEARPLATE
3	4	D3009-3	CUP

2059B HARDCOAT
6 PL

0.06
TO
0.13
HIGH

C
SYM
0.40

1.00
TYP

2.88
TYP

1.50
REF

1.00

HARDCOAT WELD
SURFACING
REF

4 PL

1/32

6

D3860-041 WEARPLATE

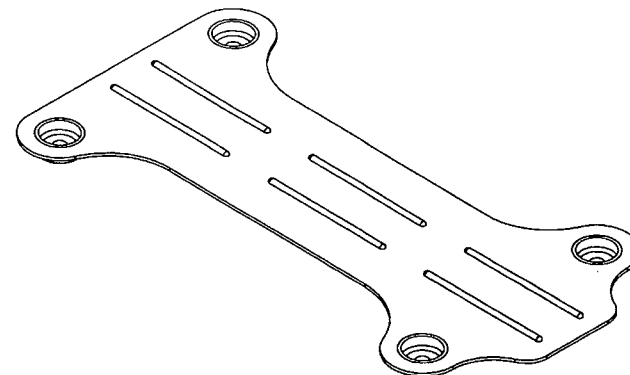
D3860-1 WEARPLATE (1)

INSTALL D3009-3 FLUSH
WITH THIS SURFACE
TYP

D3009-3 CUP (4)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3860-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.87 lbs
- 8) WELD PER DART QSI 004



83068 MLJ
12/04/13

RELEASED
09 01 26

A	NEW ISSUE		09.01.21
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3860
REV. A
SHEET 1 OF 2
SCALE
NTS

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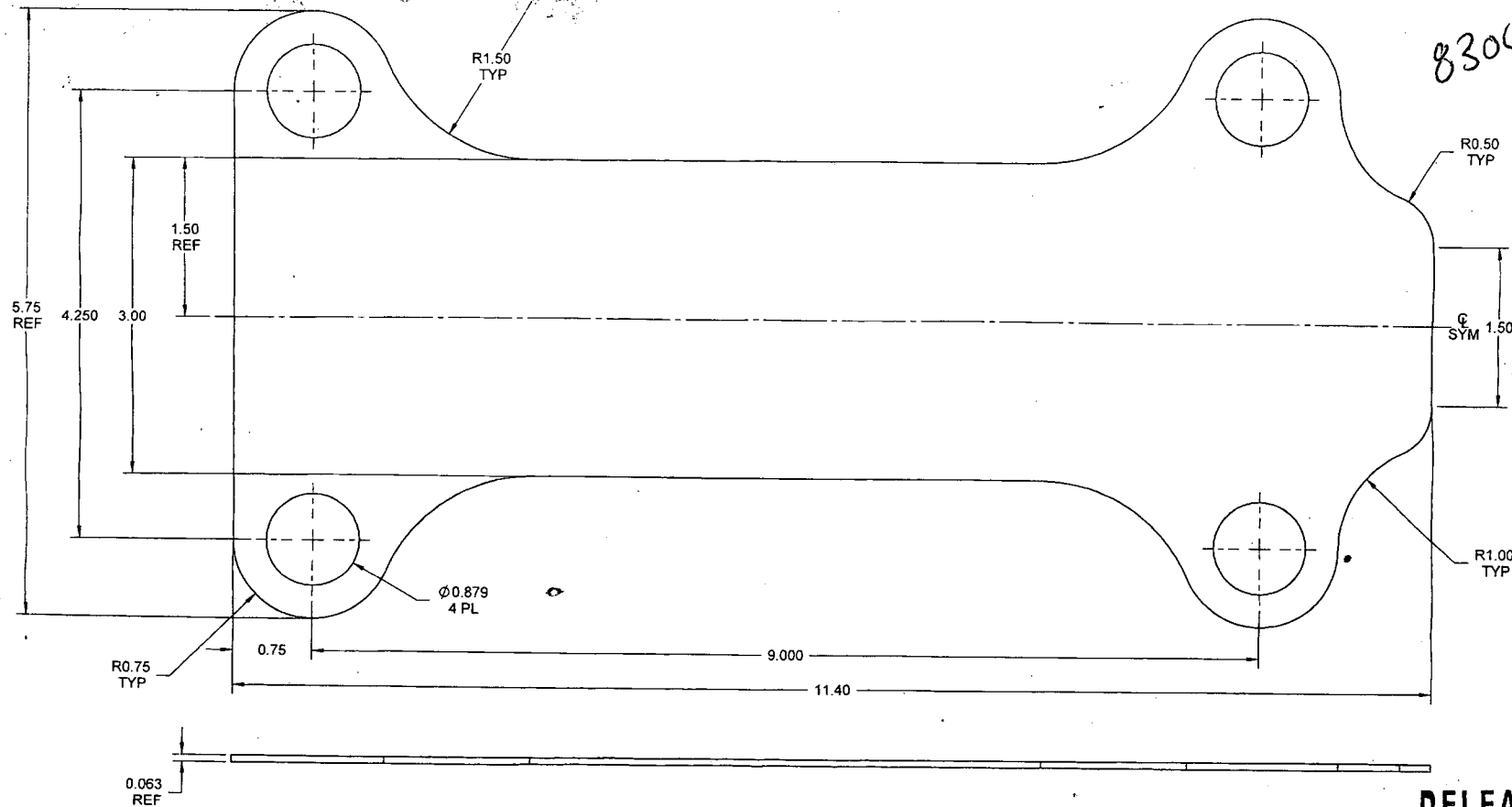
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D3860-1 WEARPLATE

RELEASED
05-01-26

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.73 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3860	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	09.01.21	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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